



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

008380

D4635-142
Job Sheet 186166



Part No: D4635-142

Job Qty: 1 pcs

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D4635 REV F SHEET 10 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/7/18		0.00	0.80	Small Fab - 1		MAR 12 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/7/18		0.00	0.00	QC 5 - 10		MAR 12 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/7/18		0.00	0.00	Packaging 3 - 1 - B4B		MAR 12 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58
				Packaging 3 - 8 - B4B	9-89 MAR 13 2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	12/7/18	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAR 13 2019 70

Part Op 110 - (Small Fab) Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300 9-89
 Descriptions: Batch: m131537 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # m138996 Expiry Date 07-19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: m138961
 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-2	Fwd Ceiling Panel, RH	1 pcs (1 ea)	110-Small Fab - 1	5134129
D4669-1	Bracket	2 Ea (2 ea)	110-Small Fab - 1	5122230
D4695-042	Channel Assembly, RH	1 pcs (1 ea)	110-Small Fab - 1	5025805
D4732-3	Label	1 pcs (1 ea)	110-Small Fab - 1	5060827
D4732-31	Label	1 pcs (1 ea)	110-Small Fab - 1	5060907
D4732-35	Label	1 pcs (1 ea)	110-Small Fab - 1	5060910
D4732-7	Label	1 pcs (1 ea)	110-Small Fab - 1	5122687
D5022-1	Foam, Side Panel, Fwd	1 pcs (1 ea)	110-Small Fab - 1	5130228

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4635-2	1	5	0
	D4669-1	2	27	0
	D4695-042	1	6	0
	D4732-3	1	4	0
	D4732-31	1	4	0
	D4732-35	1	4	0
	D4732-7	1	10	0
	D5022-1	1	10	0
Part Specifications				
Specifications could not be found.				

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D4635-142
Job Sheet 186166



Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D4635 REV F SHEET 10 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL verf: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab		
110	Small Fab	1 pcs	12/7/18	12/7/18	0.00	0.80	Small Fab		
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-2	Fwd Ceiling Panel, RH	1 Ea (1 ea)	90-Start up Operation	
D4669-1	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4695-042	Channel Assembly, RH	1 Ea (1 ea)	90-Start up Operation	
D4732-3	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-31	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-35	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-7	Label	1 Ea (1 ea)	90-Start up Operation	
D5022-1	Foam, Side Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-2	1	3	0
	D4669-1	2	34	0
	D4695-042	1	8	0
	D4732-3	1	6	0
	D4732-31	1	6	0
	D4732-35	1	6	0
	D4732-7	1	6	0
	D5022-1	1	5	0
Part Specifications				
Specifications could not be found.				

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- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART)
TO BOND D4669-1 & D4695-042. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-1 FOAM ON D4635-2

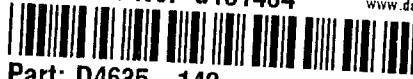
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 10 OF 16
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S161464



Part: D4635-142

Job No: 186166

Serial No/Batch: S161464

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/12/19